



Phone: (517) 295-4196 Fax: (517) 295-4918

Technical Data Sheet
LCA® PEI 1000 Type
General Purpose Polyetherimide

Typical Compound Properties	Value / Measure		Test Methods
Physical Properties			
	English Units (ISO)	Metric Units	
Melt Flow Rate @ 300 / 1.2	9 g/10 min		ASTM D-1238
Density	1.27 g/cm ³	1.27 g/cm ³	ASTM D-792
Linear Mold Shrinkage	0.005 - 0.007 in/in	0.005 - 0.007 mm/mm	ASTM D-955
Mechanical Properties			
Izod Impact - Notched	1 ft-lb/in (kJ/m)	53 J/m	ASTM D-256
Tensile Strength @ Yield	15,000 psi (Mpa)	103 MPa	ASTM D-638
Tensile Strength @ Break	psi (Mpa)	0 MPa	ASTM D-638
Tensile Elongation @ Yield	%	0 %	ASTM D-638
Tensile Elongation @ Break	60 %	60 %	ASTM D-638
Flexural Strength @ Yield	23,000 psi (Mpa)	159 MPa	ASTM D-790
Flexural Stress @ Break	psi (Mpa)	0 MPa	ASTM D-790
Flexural Stress @ 5% Strain	psi (Mpa)	0 MPa	ASTM D-790
Flexural Modulus	500,000 psi (Mpa)	3,450 MPa	ASTM D-790
Thermal Properties			
DTUL @ 66 psi (455 kPa)	Deg. F	Deg. C	ASTM D-648
@ 264 psi (1820 kPa)	385 Deg. F	196 Deg. C	ASTM D-648
Vicat Softening Temperature	Deg. F	Deg. C	ASTM D-1525

All tests are performed on dry as molded ASTM (ISO) test bars.

General Product Type Information

Flame Rating (3.0 mm)	UL94	V-2 @ 0.400mm V-0 @ 0.750mm 5VA@ 3.00mm
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The property values listed above have been obtained using laboratory controlled test methods. They are offered without guarantee since conditions under which the product is used are beyond our control. Therefore, Uniplus, Inc. disclaims any liability for loss or damage incurred in connection with the use of this product.

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Typical Processing Conditions

Process Variable	Description	Values
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Temperatures		F	C
Barrel	Rear	332 - 399	
	Center	338 - 399	
	Front	343 - 399	
	Nozzle	343 - 399	
	Melt Temp	349 - 399	

Drying	
Type	Dehumidifier
Temperature	149°C
Time	4 - 6 hours

Special Requirements

Optimum processing conditions will depend on such factors as machine size, screw design, part dimension, mold design, runner and gate design, and material residence time. These recommendations are intended only as a guide to achieve stable processing and good part quality.

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